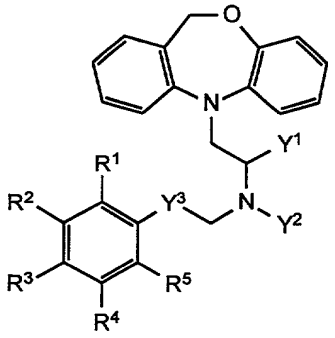
What is claimed is:

1. A process for producing a 5-substituted-5,11-dihydro-dibenzo [b,e][1,4]oxazepine compound having the formula (3) or a stereoisomer thereof:

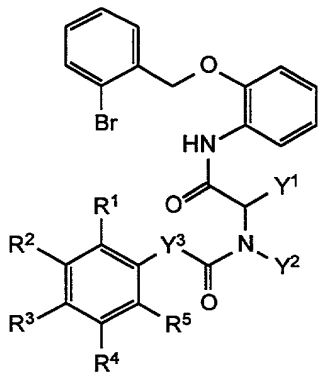


(3)

wherein: Y^1 is hydrogen; Y^2 is hydrogen or lower alkyl, or Y^1 and Y^2 together represent $-CH_2-CH_2-CH_2$ or $-CH_2-CH_2-CH_2-CH_2$; Y^3 is $-CH_2-$; - or $-CH_2-CH$; and R^1 to R^5 are each the same or different from one another and each represents hydrogen, halogen, lower alkyl, hydroxyl, lower alkoxyl, amino or lower alkylamino, or R^1 and R^2, R^2 and R^3, R^3 and R^4 or R^4 and R^5 together form $-OCH_2O-$;

which process comprises the steps of:

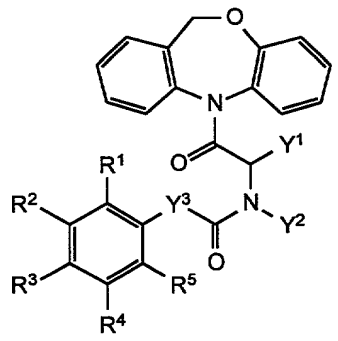
a) intramolecularly arylating a [2-(2-bromobenzyloxy)phenyl]amide compound of the formula (1):



(1)

wherein Y^1, Y^2 and Y^3 and R^1 to R^5 are as defined above;

to form a 5,11-dihydro-dibenzo[b,e][1,4]oxazepine compound of the formula (2):

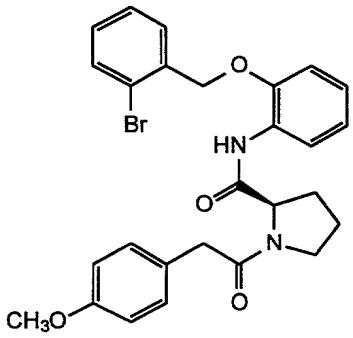


(2)

wherein Y^1, Y^2 and Y^3 and R^1 to R^5 are as defined above; and

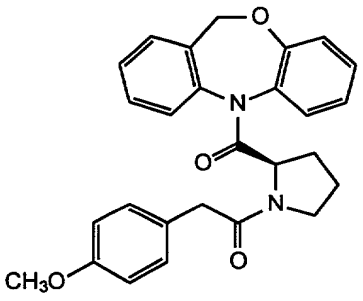
b) reducing the compound of the formula (2).

2. The process of Claim 1, wherein the [2-(2-bromobenzyloxy)phenyl]amide compound of the formula (1) is (R)-1-[(4-methoxyphenyl)acetyl]pyrrolidine-2-carboxylic acid [2-(2-bromo benzyloxy)phenyl]amide of the formula (4):



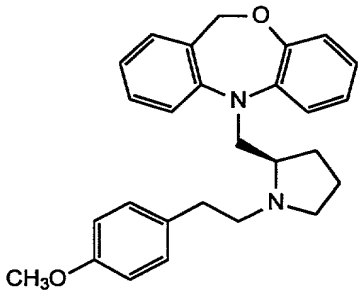
(4)

the 5,11-dihydro-dibenzo[b,e][1,4]oxazepine compound having the formula (2) is (R)-[[2-(5,11-dihydro-dibenzo[b,e][1,4]oxazepine-5-carbonyl)pyrrolidin]-1-yl]-2-(4-methoxyphenyl)ethanone of the formula (5):



(5)

and the 5-substituted-5,11-dihydro-dibenzo[b,e][1,4]oxazepine compound of the formula (3) or the stereoisomer thereof is (R)-(+)-5,11-dihydro-5-[1-(4-methoxyphenethyl)-2-pyrrolidinylmethyl]dibenzo[b,e][1,4]-oxazepine of the formula (6):



(6)

3. The process of Claim 2, which comprises the steps of crystallizing (R)-[[2-(5,11-dihydro-dibenzo[b,e][1,4]oxazepine-5-carbonyl)pyrrolidin]-1-yl]-2-(4-methoxyphenyl)ethanone of the above formula (5) obtained by the intramolecular arylation, isolating and then reducing the resulting crystals.

4. The process of Claim 1, wherein Y^2 is C_1-C_4 alkyl.

5. The process of Claim 1, wherein Y^3 is $-CH_2-$.

6. The process of Claim 1, wherein the compound of the formula (1) is dissolved in a solvent.

7. The process of Claim 6, wherein the solvent comprises toluene, pyridine, picoline, ethylpyridine, DMF or diphenyl ether.

8. The process of Claim 1, wherein step (a) is effected in the presence of a metal catalyst and an inorganic base under inert gas at a temperature of about 100 to 150°C.

9. The process of Claim 8, wherein the metal catalyst is cuprous bromide, the inorganic base is potassium carbonate and the solvent is pyridine or picoline.

10. The process of Claim 1, which further comprises crystallizing the compound of

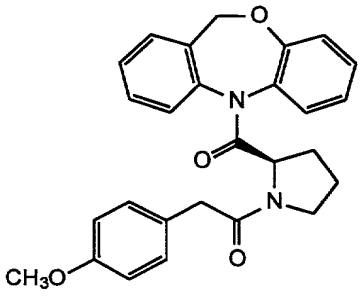
the formula (2) prior to reduction step (b).

11. The process of Claim 10, wherein the crystallization is effected in toluene.

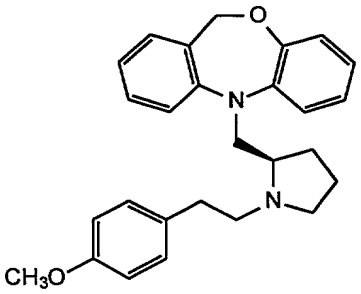
12. The process of Claim 1, wherein step (b) comprises reducing the compound of the formula (2) in a solvent by adding sodium borohydride and boron trifluoride/tetrahydrofuran complex thereto under inert gas at a temperature of from about 5 to 60°C.

13. The process of Claim 12, wherein said solvent is tetrahydrofuran.

14. A process for producing (R)-(+)-5,11-dihydro-5-[1-(4-methoxyphenethyl)-2-pyrrolidinylmethyl]dibenzo[b,e][1,4]oxazepine of the following formula (6), which comprises the steps of crystallizing (R)-[[2-(5,11-dihydro-dibenzo[b,e][1,4]oxazepine-5-carbonyl)pyrrolidin]-1-yl]-2-(4-methoxyphenyl)ethanone of the following formula (5), isolating and then reducing the resulting crystals:

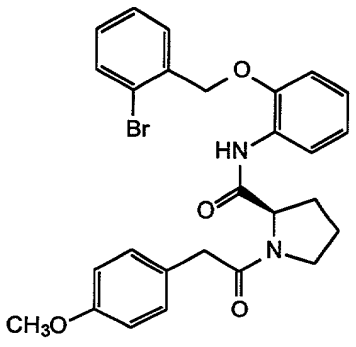


(5)



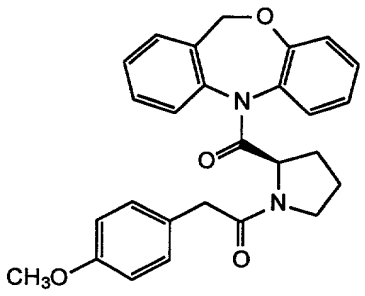
(6)

15. (R)-1-[(4-Methoxyphenyl)acetyl]pyrrolidine-2-carboxylic acid [2-(2-bromobenzyloxy)phenyl]amide of the formula (4):



(4)

16. (R)-[[2-(5,11-Dihydro-dibenzo[b,e][1,4]oxazepine-5-carbonyl) pyrrolidin]-1-yl]-2-(4-methoxyphenyl)ethanone of the formula (5):



(5)

17. Crystals of (R)-[[2-(5,11-dihydro-dibenzo[b,e][1,4]oxazepine-5-carbonyl)pyrrolidin]-1-yl]-2-(4-methoxyphenyl)ethanone.

18. The crystals of Claim 17, which satisfy at least one of the following conditions a and b:

a: melting point: 132 to 134°C, and

b: powder X ray crystal analysis: 2θ = 7.9° 9.0° 14.4° 23.8°

19. The crystals of Claim 17, which satisfy at least one of the following conditions a and b:

a: melting point: 148 to 150°C, and

b: powder X ray crystal analysis: 2θ= 12.5° 18.5° 19.3° 21.1° 21.4°

20. The crystals of Claim 18, which satisfy both conditions a and b.

21. The crystals of Claim 19, which satisfy both conditions a and b.

22. A method of converting crystals of (R) -[[2-(5,11-dihydro-

dibenzo[b,e][1,4]oxazepine-5-carbonyl)pyrrolidin]-1-yl]-2-(4-methoxyphenyl)ethanone which satisfy at least one of the following conditions a and b:

a: melting point: 132 to 134°C, and

b: powder X ray crystal analysis: 2θ = 7.9° 9.0° 14.4° 23.8° (crystals 1)

into crystals which satisfy at least one of the following conditions a and b:

a: melting point: 148 to 150°C, and

b: powder X ray crystal analysis: 2θ= 12.5° 18.5° 19.3° 21.1° 21.4° (crystals 2)

which comprises the steps of suspending the crystals 1 in toluene and stirring the obtained suspension at about 10° to 50°C.